



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4884-3

Job Sheet 184457



Part No: D4884-3

Job Qty: 4 ea

Part Name: End Fitting, Eye



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD REV: B MAKE PART IN HOUSE RQ
16.12.06

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Machining-3		
105	CNC Lathe	4 pcs	10/31/18	10/31/18	0.00	5.87	Doosan		
115	CNC Vertical Machining	4 pcs	10/31/18	10/31/18	0.00	5.87	HAAS1-5		
117	QC	4 pcs	10/31/18	10/31/18	0.00	0.00	QC2 Machining-3		
120	QC	4 pcs	10/31/18	10/31/18	0.00	0.00	QC8 Machining-3		
130	Outsource	4 pcs	10/31/18	10/31/18	0.00	0.00	Outsource2		
140	Packaging	4 pcs	10/31/18	10/31/18	0.00	0.00	Packaging2		
150	QC	4 pcs	10/31/18	10/31/18	0.00	0.00	QC5		
160	Packaging	4 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-2		
170	QC21-SA	4 Ea	10/31/18	10/31/18	0.00	0.00	QC21		

Part Op 117 - QC2- Inspect parts off machine FAI/FAIB
Descriptions: 120 - QC8- Inspect parts - second check
130 - Outsource process - NDT per QSI038 4.1
140 - Receive & Inspect for Damage & Mat'l Certs
150 - QC5- Inspect part completeness to step on W/O
160 - Identify as per dwg & Stock Location:
170 - QC21- Final Inspection - Work Order Release

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NOV 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.500	17-4 SS H900 Round Bar 1.500"	1.4000 ft (.35 ea)	90-Start up Operation	M124 892

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R1.500	1	82	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		and / Supervisor oval Verification
		/ QA Coordinator Approval

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/22/18

Root Cause		FAULT CATEGORY	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER :	



Container No: S120418

Part: D4884-3

Job No: 184457

Serial No/Batch: S120418

Revision:

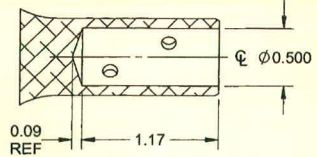
Inspector:

Exp Date:

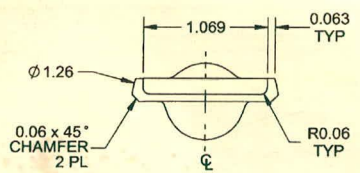
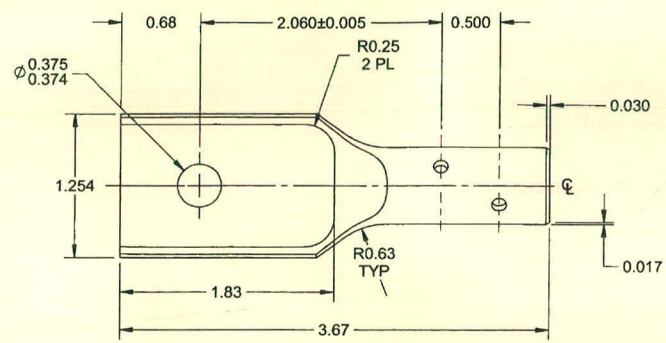
Instructions: Various STC's

Out of Sequence ☐Off-set ☐Mislabeled ☐Fit/Function ☐Misaligned/off center ☐Positioned Wrong ☐Outside Dimensions ☐Over/Under tolerance ☐Part Incorrect ☐Part Lost/Missing ☐Part Moved ☐Drawing ☐Finish ☐Misread ☐Turning Sequence ☐

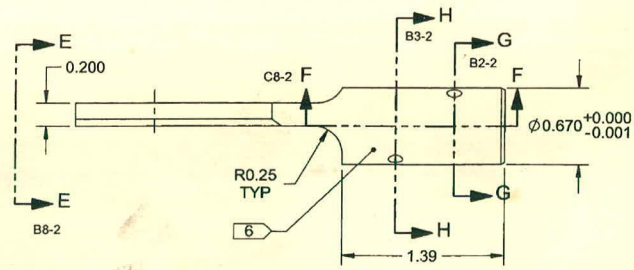
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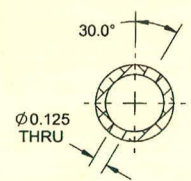
SECTION F-F C5-2



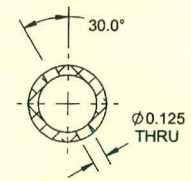
VIEW E-E B6-2



D4884-3 END FITTING, EYE



SECTION G-G C4-2



SECTION H-H C5-2

- NOTES:**
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.14 lbs
 - 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4884	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	END FITTING	NTS
DATE	13.12.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

2013-12-12

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041806**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041806
PO Date: 11/21/18
Due Date: 11/28/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184457	D4884-3	End Fitting, Eye : Various STC's Outsource process - NDT per QSI038 4.1	Firmed	-	11/28/18	4 pcs	0 pcs	4 pcs	\$68.20/pcs	\$272.80
2	183453-A	D4884-1	End Fitting, Eye : Various STC's ISSUE P/O	Firmed	-	11/28/18	6 pcs	0 pcs	6 pcs	\$68.20/pcs	\$409.20
3	182141	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	183771		NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	182139		NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	182142		NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
Sub Total:							4	0	4		\$272.80

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PURCHASE ORDER **PO041806**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	186378	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
										Grand Total:	\$1,023.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/21/18 3:28 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38261	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: P0041774
Descr:	PN:	S/N:	Qty: 1 P/O: 041806
Make:	Model:	Reg:	A/C S/N: NOV 23 2018
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING PARTS:

P/N: D4884-3 END FITTINGS, EYE JOB SHEET# 184457 (4 ea.) ✓

P/N: D4884-1 END FITTINGS, EYE JOB SHEET# 183453-A (6 ea.) ✓

P/N: D212-664-201 AFT CROSSTUBE - HIGH

JOB SHEET# 183771 ✓ JOB SHEET# 182141 ✓

JOB SHEET# 182139 ✓ JOB SHEET# 182142 ✓

P/N: D212-664-101 FWD CROSSTUBE - HIGH

JOB SHEET# 186378 ✓

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE AS PER ASTM1417M-16						20 NOV 2018	DAS 38 2-89 DOT-APP 36 53-89 G
NO CRACK FOUND							
PEN (ZL-56, MPO13600), DEV. (SKD-S2, MPO11715), CLEANER (SKC-S, MPO19368)							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp DOT-APP 36 53-89	Date: 20 NOV 2018
Name: CHRISTIAN BRIEN		

1992-1993